



Dart Aerospace Ltd.
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Canada

Tel (613) 632-5200

D350-591-311
Job Sheet 171529



Part No: D350-591-311

Job Qty: 3 ea

Part Name: Heli-Access-Step™ LH - High Gear, Long Step, Aerazur Float Compatible



Part Weight: 0 lbs

Status: Scheduled

Priority: High

Job Created: 2/2/18

Job Tracking No:

Due Date: 2/9/18

Created By: Jason Leroux

Type: SOLD

Description:

Note: DWG REV B IPP Rev:A 04.03.22 New issue KJ/RF IPP Rev:B 07-06-09 Added D3272-1 JLM IPP C returned to CHG001 for Eurocopter, ref NCR08-082 LL verified by:EC IPP Rev:D fixe route seq in bom DD 10.04.28 verified by:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	3 Ea	2/8/18	2/8/18	0.00	0.00	Start Up Large Fab-4		SL 2/5/18
110	Large Fab	3 pcs	2/8/18	2/8/18	0.00	2.97	Large Fab 2		SL 2/6/18
120	QC	3 pcs	2/8/18	2/8/18	0.00	0.00	QC9		CPL
130	QC	3 pcs	2/8/18	2/8/18	0.00	0.00	QC5		CPL
140	HandFinish	3 pcs	2/8/18	2/8/18	0.00	0.55	HandFinish1		18-02-06
150	QC	3 pcs	2/8/18	2/8/18	0.00	0.00	QC7-2		CPL
180	Large Fab	3 pcs	2/8/18	2/8/18	0.00	2.97	Large Fab 2		SL
190	QC	3 pcs	2/8/18	2/8/18	0.00	0.00	QC10		CPL
200	QC	3 pcs	2/8/18	2/8/18	0.00	0.00	QC5		CPL
210	HandFinish	3 pcs	2/8/18	2/8/18	0.00	0.55	HandFinish1		18-02-13
220	Powdercoat	3 pcs	2/8/18	2/8/18	0.00	0.87	Powdercoat1		BR 18-2-21
230	HandFinish	3 pcs	2/9/18	2/9/18	0.00	0.55	HandFinish3		18-02-21
240	QC	3 pcs	2/9/18	2/9/18	0.00	0.00	QC3		
250	Packaging	3 pcs	2/9/18	2/9/18	0.00	0.00	Packaging1-3		SL FEB 22 2018
260	QC	3 pcs	2/9/18	2/9/18	0.00	0.00	QC4		SMB
265	DC	3 pcs	2/9/18	2/9/18	0.00	0.00	DC		
270	Packaging	3 pcs	2/9/18	2/9/18	0.00	0.00	Packaging3-1		SMB
280	QC21-FG	3 Ea	2/9/18	2/9/18	0.00	0.00	QC21		FG084

Part Op 110 - 1-Bevel end for welding FWD ONLY 2-Weld Support using Jig DT8719, weld Fwd End Plate as per QSI 004 & Dwg Descriptions: D3272 A/R Aluminum Rod 138673 3-Grind End Plate flush

180 - 1-Assemble Leg Assembly as per Dwg D3272. 2-Leave one rivet out until welding is complete. 3-Bevel Aft end for welding 4-Inspect for foreign object as per QSI 024 5-Weld Aft End Plate as per QSI 004 & Dwg D3272 A/R Aluminum Rod 138675 6-Grind End Plate flush 7-Install last rivet as per Dwg.

220 - START TIME: 8:00 OVEN TEMPERATURE: 350° FINISH TIME: 9:20

265 - Photocopy bluefile and type labels as per PPP D350-591-311 CHG001

270 - Identify and pack for shipping as per PPPD350-591-311 Location : FG084

Wing walk M138761

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D3067-1	End Plate	3 Ea (1 ea)	90-Start up Operation	
D3219-1	Plate	6 Ea (2 ea)	90-Start up Operation	
D3272-1	Step	3 Ea (1 ea)	90-Start up Operation	
D3065-041	Step Leg Assembly	3 Ea (1 ea)	180-Large Fab	
D3066-1	Spacer	6 Ea (2 ea)	180-Large Fab	
D3067-1	End Plate	3 Ea (1 ea)	180-Large Fab	
MS20600-AD4W4	Rivet	48 Ea (16 ea)	180-Large Fab	
AN3-35A	Bolt	6 Ea (2 ea)	250-Packaging	
AN4-13A	Bolt	24 Ea (8 ea)	250-Packaging	
AN5-36A	Bolt	6 Ea (2 ea)	250-Packaging	
D2230-3	Mounting Lug	12 Ea (4 ea)	250-Packaging	
D2618	Bushing	6 Ea (2 ea)	250-Packaging	
D2856-400-720	Abrasion Strip 4" X 7.20"	6 Ea (2 ea)	250-Packaging	
D3235-1	Mounting Lug	6 Ea (2 ea)	250-Packaging	
D3278-041	Support Assembly	3 Ea (1 ea)	250-Packaging	
MS21042L3	Nut	6 Ea (2 ea)	250-Packaging	
MS21042L4	Nut	24 Ea (8 ea)	250-Packaging	
MS21042L5	Nut	6 Ea (2 ea)	250-Packaging	
NAS1149D0363J	Washer	12 Ea (4 ea)	250-Packaging	
NAS1149D0463J	Washer	48 Ea (16 ea)	250-Packaging	
NAS1149D0563J	Washer	12 Ea (4 ea)	250-Packaging	
DSI 9410-011	Amends Installation Of D350-591-311/-312 Steps	3 Ea (1 ea)	250-Packaging	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D3067-1	3	101	0
	D3219-1	6	106	0
	D3272-1	3	0	0
180-Large Fab	D3065-041	3	2	0
	D3066-1	6	90	0
	D3067-1	3	101	0
250-Packaging	MS20600-AD4W4	48	1,321	0
	AN3-35A	6	182	0
	AN4-13A	24	690	0
	AN5-36A	6	108	0
	D2230-3	12	169	0
	D2618	6	58	0
	D2856-400-720	6	163	0
	D3235-1	6	43	0
	D3278-041	3	30	0
	DSI 9410-011	3	4	0
	MS21042L3	6	2,133	0
	MS21042L4	24	2,249	0
	MS21042L5	6	537	0
	NAS1149D0363J	12	3,781	0
	NAS1149D0463J	48	3,660	0
	NAS1149D0563J	12	873	0

Part Specifications

Specifications could not be found.

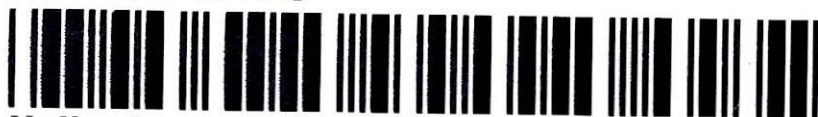
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06/08/

DART
AEROSPACE
S038939

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Heli – Access – Step LH – High Gear, Long Step, Aerazur
Float Compatible

PART NO: D350 – 591 – 311

Original Serial #: S038939

Revision:

Operation: Start up Operation 02/05/18

Change No: CHG002

Job No: 171529



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Master Unit 001081

Containers on Master Unit 001081				
Serial No	Part No	Customer Part No	Status	Quantity
S044273	AN3-35A		Allocated	6
S044272	AN4-13A	AN4-13A	Allocated	24
S044271	AN5-36A	AN5-36A	Allocated	6
S044269	D2230-3	D2230-3	Allocated	12
S025116	D2618	D2618	Allocated	6
S044267	D2856-400-720	D2856-400-720	Allocated	6
S044266	D3278-041	D3278-041	Allocated	3
S044265	MS21042L3	MS21042L3	Allocated	6
S044264	MS21042L4	MS21042L4	Allocated	24
S044263	MS21042L5	MS21042L5	Allocated	6
S044262	NAS1149D0363J	NAS1149D0363J	Allocated	12
S044260	NAS1149D0463J	NAS1149D0463J	Allocated	48
S044258	NAS1149D0563J	NAS1149D0563J	Allocated	12

QC4 6 X D3235-1 S044985

Qty -213	Qty -214	Qty -215	Qty -216	Qty -311	Qty -312	Part Number	Description
X						D350-591-213	<i>Heli-Access-Step™</i> , Short Step – High Skid, LH
	X					D350-591-214	<i>Heli-Access-Step™</i> , Short Step – High Skid, RH
		X				D350-591-215	<i>Heli-Access-Step™</i> , Short Step – Low Skid, LH
			X			D350-591-216	<i>Heli-Access-Step™</i> , Short Step – Low Skid, RH
				X		D350-591-311	<i>Heli-Access-Step™</i> , Long Step – High Skid, LH
					X	D350-591-312	<i>Heli-Access-Step™</i> , Long Step – High Skid, RH
1						D3078-041	STEP ASSEMBLY (HIGH-SHORT, LH)
	1					D3078-042	STEP ASSEMBLY (HIGH-SHORT, RH)
		1				D3168-041	STEP ASSEMBLY (LOW-SHORT, LH)
			1			D3168-042	STEP ASSEMBLY (LOW-SHORT, RH)
				1		D3272-041	STEP ASSEMBLY (HIGH-LONG, LH)
					1	D3272-042	STEP ASSEMBLY (HIGH-LONG, RH)
2	2	2	2	4	4	D2230-3	MOUNTING LUG
2	2	2	2	2	2	D2618	BUSHING
4	4	4	4			D2732-030	CUSHION
				2	2	D2856-400-720	ABRASION STRIP
2	2	2	2	2	2	D3235-1	MOUNTING LUG
				1	1	D3278-041	SUPPORT ASSEMBLY
2	2	2	2	2	2	AN3-35A	BOLT
				8	8	AN4-13A	BOLT
4	4	4	4			AN4-15A	BOLT
2	2	2	2	2	2	AN5-36A	BOLT
4	4	4	4	4	4	NAS1149D0363J	WASHER (AN960JD10)
12	12	12	12	16	16	NAS1149D0463J	WASHER (AN960JD416)
4	4	4	4	4	4	NAS1149D0563J	WASHER (AN960JD516)
2	2	2	2	2	2	MS21042L3	NUT
8	6	6	6	8	8	MS21042L4	NUT
2	2	2	2	2	2	MS21042L5	NUT
				1	1	*DSI 9410-011	STEP MODIFICATION KIT

*DSI 9410-011 Step Modification Kits are provided with all D350-591-311 and D350-591-312 Steps. This kit is provided as an option for the installer and is therefore **NOT REQUIRED** to complete the installation of the D350-591-311 or D350-591-312 Steps. Refer to Figure 15 for installation of the DSI 9410-011 Kit.

Change Record

PAGE 1 OF 1

Part Number: D350-591-311/-312 (EURO P/N: 704A 41 640 012/-011)

Description: HELI-ACCESS STEP, HIGH SKID, LONG STEP, LH/RH

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